

# Work Order ID 45531

July 24, 2009 7:31:20 AM



Page 1

Item ID: D130-780-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft LH Door Hinge Kit

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D130-780-011

CHG 001

ECN 09-541 ADDED

for JUD 09/03/09 = ) S 09/17/09

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

9/1/24 QSP

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

⇒ S 09/17/09

Ⓢ Ⓟ

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
050724	110 Kit picking	Add Qty 2 NAS1149D05633 washer to kit	CE	09.07.24		050724	050724	
		Add to pick list (NCR 09-078 already addresses this) per in change						
		↳ QTY Addition of the washer.						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 11 Date: 09.07.27  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/20	Pick kit	missing parts on pick list. transferred from R.L. not transfer	051022	ADD missing parts to kit MS24665-212 outer pin B# 111499 Qty x2 per kit	SP 9/7/20	S 09/07/20	051022	051022
		<del>lost</del> COSC to Intertwine	051022	<del>MS24665-212 outer pin</del> B# 111499 Qty x2 per kit MS24694546 screw B# 111499 Qty x3 per kit AD960ND10 Q51 4.2.11 NAS1149D03633 washer B# 111668 Qty x8 per kit	SP 9/7/20 SP 9/7/20	S 09/07/20 S 09/07/20	051022	051022
			051022	NAS1149D04633 washer B# 110914 Qty x2 per kit	SP 9/7/20	S 09/07/20	051022	051022
			051022	Adjust BOM AND attach a copy of updated version.	SP 09/07/20	S 09/07/20	051022	051022

NOTE: Date &amp; initial all entries

Status	Item ID	Rev	Name	Start Date	Quantity Per	UOM	Scrap %	Route Seq ID	Sort	Date Last Mod	Add Date	Comments
✓	D3892-1	Prelim	Seal	06/24/09	1.0000	Each	0 %	110	1	07/20/09 11:38...	06/24/09	
✓	D3813-041	A	Hinge Assembly,...	06/24/09	1.0000	Each	0 %	110	2	07/20/09 11:38...	06/24/09	
✓	D3813-043	A	Hinge Assembly,...	06/24/09	1.0000	Each	0 %	110	3	07/20/09 11:38...	06/24/09	
✓	D3814-1	A	Hinge, Upper Airfr...	06/24/09	1.0000	Each	0 %	110	4	07/20/09 11:38...	06/24/09	
✓	D3814-3	A	Hinge, Lower Airfr...	06/24/09	1.0000	Each	0 %	110	5	07/20/09 11:38...	06/24/09	
✓	D3816-1	A	Spacer	06/24/09	2.0000	Each	0 %	110	6	07/20/09 11:38...	06/24/09	
✓	D3816-3	A	Spacer	06/24/09	4.0000	Each	0 %	110	7	07/20/09 11:38...	06/24/09	
✓	D3817-041	A	Anchor Nut Plate	06/24/09	1.0000	Each	0 %	110	8	07/20/09 11:38...	06/24/09	
✓	AN3-5A		Bolt	06/24/09	2.0000	Each	0 %	110	9	07/20/09 11:38...	06/24/09	
✓	AN3-7A		Bolt	06/24/09	3.0000	Each	0 %	110	10	07/20/09 11:38...	06/24/09	
✓	AN310-4		NUT	06/24/09	2.0000	Each	0 %	110	11	07/20/09 11:38...	06/24/09	
✓	AN4-17		BOLT	06/30/09	2.0000	Each	0 %	110	12	07/20/09 11:38...	<del>06/30/09</del>	
✓	AN970-4		Washer	06/24/09	2.0000	Each	0 %	110	13	07/20/09 11:38...	06/24/09	
✓	MS21042L3		Nut	06/24/09	5.0000	Each	0 %	110	14	07/20/09 11:38...	06/24/09	
✓	MS24665-2-12		COTTER PIN	06/30/09	2.0000	Each	0 %	110	15	07/20/09 11:38...	<del>06/30/09</del>	
✓	MS24694-S46		SCREW	06/30/09	3.0000	Each	0 %	110	16	07/20/09 11:38...	<del>06/30/09</del>	
✓	AN960JD10		Washer	07/01/09	8.0000	Each	0 %	110	17	07/01/09 9:48 AM	07/01/09	
✓	NAS1149D0463J		Washer	06/24/09	2.0000	Each	0 %	110	18	07/20/09 11:38...	<del>06/24/09</del>	
✓	D3552-7	D	Door Prop	06/24/09	1.0000	Each	0 %	110	19	07/20/09 11:38...	06/24/09	
✓	D3622-1	A	Ball Stud	06/24/09	2.0000	Each	0 %	110	20	07/20/09 11:38...	06/24/09	
✓	D3820-1	A	Bracket	06/24/09	1.0000	Each	0 %	110	21	07/20/09 11:38...	06/24/09	
✓	MS21042L5		Nut	06/24/09	2.0000	Each	0 %	110	22	07/20/09 11:38...	06/24/09	

→ Sub. NAS1149D0363J

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Item ID: D130-780-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft LH Door Hinge Kit

Start Date: 7/15/09 Start Qty: 1.00

Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Packaging						9/7/24		54	(1)
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D130-780-011								
	Location: _____								
	PPP rev: <u>A</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	Memo	0.00							

see pto for extrus  
Hardware pulled.

u 8-07-24

# Picklist Print

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Page 1

Work Order ID: 45531

Parent Item: D130-780-011

Parent Item Name: SPACER

Comments:


*After LH door  
Huge Ket*

Start Date: 7/15/09


Required Date: 8/03/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN310-4 <i>x2</i>  NUT		Purchased	No				Each	40.0000	2.0000		<i>9/7/17</i>	<i>SP</i>

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	40	
110098	40	

✓ AN3-5A <i>x2</i>  Bolt		Purchased	No				Each	2,566.000	2.0000		<i>110098</i> <i>9/7/17</i>	<i>SP</i>
---	--	-----------	----	--	--	--	------	-----------	--------	--	--------------------------------	-----------

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2566	
100188	248	
105057	2246	
15205	72	

✓ AN3-7A <i>x3</i>  Bolt		Purchased	No				Each	132.0000	3.0000		<i>15205</i> <i>9/7/17</i>	<i>SP</i>
---	--	-----------	----	--	--	--	------	----------	--------	--	-------------------------------	-----------

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	132	
110704	32	
111127	100	

*110704*

*(A)*

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Page 2

Work Order ID: 45531

Parent Item: D130-780-011

Parent Item Name: SPACEPOD

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 Washer		Purchased	No				Each	1,246.000	8.0000		9/7/17	56

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1246	
105442	95	
109059	2	
109840	23	
110985	202	
111279	13	
111668	911	

11668

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Shop Packet Print

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# Picklist Print

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Page 3

Work Order ID: 45531

Parent Item: D130-780-011

Parent Item Name: SPACEPOD

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No				Each	1,603.000	2.0000			
Washer												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1603	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	296	
112082	1000	

Equivalent to  
NAS1149D05635

111279

12

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# Picklist Print

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Work Order ID: 45531

Parent Item: D130-780-011

Parent Item Name: SPACEPOD

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN970-4 Washer		Purchased	No				Each	128.0000	2.0000		9/17/11	SEP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	128	
104885	3	
107242	3	
107715	1	
108077	2	
108377	19	
111724	3	
112082	97	

✓ D3552-7RevD Door Prop		Manufactured	No				Each	16.0000	1.0000		9/17/11	SEP
----------------------------	--	--------------	----	--	--	--	------	---------	--------	--	---------	-----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
32644	16	



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Work Order ID: 45531

Parent Item: D130-780-011

Parent Item Name: SPACEPOD


Comments:

Start Date: 7/15/09


Required Date: 8/03/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3622-1RevA S  Ball Stud		Manufactured	No				Each	33.0000	2.0000		9/1/17 SP	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	33	
46451	13	
48629	20	

SV D3813-041RevA H  Hinge Assembly, Upper Door	Manufactured	No	Each	4.0000	1.0000	46451	9/1/17 SP
---	--------------	----	------	--------	--------	-------	-----------

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
45727	4	

SV D3813-043RevA H  Hinge Assembly, Lower Door	Manufactured	No	Each	4.0000	1.0000	45727	9/1/17 SP
---	--------------	----	------	--------	--------	-------	-----------

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
45728	4	

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# Picklist Print

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Page 6

Work Order ID: 45531

Parent Item: D130-780-011

Parent Item Name: SPACEPOD


Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S ✓ D3814-1RevA  Hinge, Upper Airframe		Manufactured	No				Each	5.0000	1.0000		9/11/17	SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

45673

5

Each

2.0000

1.0000

45673

9/11/17 SP

S ✓ D3814-3RevA  Hinge, Lower Airframe		Manufactured	No				Each	2.0000	1.0000			
---	--	--------------	----	--	--	--	------	--------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

45674

2

Each

24.0000

2.0000

45674

9/11/17 SP

S ✓ D3816-1RevA  Spacer		Manufactured	No				Each	24.0000	2.0000			
--	--	--------------	----	--	--	--	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

24

42077

6

45675

18

42077

10

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Shop Packet Print

Page 6

# Picklist Print

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Page 7

Work Order ID: 45531

Parent Item: D130-780-011

Parent Item Name: SPACEPOD

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S✓ D3816-3RevA \*4 Manufactured No



Spacer

Each 33.0000 4.0000



9/17/17 SQ

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 33

42078 2

45676 11

46040 20

42078  
45676

S✓ D3817-041RevA H Manufactured No



Anchor Nut Plate

Each 4.0000 1.0000



9/17/17 SQ

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 4

45730 4

45730

S✓ D3820-1RevA H Manufactured No



Bracket

Each 27.0000 1.0000



9/17/17 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 27

42079 1

45732 26

45732

①

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Shop Packet Print

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# Picklist Print

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Page 8

Work Order ID: 45531

Parent Item: D130-780-011

Parent Item Name: SPACEPOD

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

✓ D3892-1RevPrelim Manufactured No

Each 100.0000 1.0000



Seal

5<sup>th</sup> seal attached

Warehouse	Location	Loc Qty	Loc Code
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Main Warehouse

ST 100

47330 100

47330 9/7/24 SP

SV MS21042L3 x5 Purchased No

Each 1,873.000 5.0000



Nut

Warehouse	Location	Loc Qty	Loc Code
-----------	----------	---------	----------

Main Warehouse

ST 1873

110844 34

111274 839

111668 1000

111274

SV MS21042L5 x2 Purchased No

Each 791.0000 2.0000



Nut

Warehouse	Location	Loc Qty	Loc Code
-----------	----------	---------	----------

Main Warehouse

ST 791

110382 10

111127 281

111636 500

111127

9/2/17

SP  
(K)

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Shop Packet Print

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# Checklist Print

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Work Order ID: 45531

Parent Item: D130-780-011

Parent Item Name: SPACEPOD


Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S NAS1149D0463J	12	Purchased	No				Each	280.0000	2.0000		9/7/17	SP
												
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	280	
110914	280	

110914

10

Date: Thursday, 05/02/2009 3:30:52 PM  
User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services <b>Job Number</b> : 45531 <b>Estimate Number</b> : 13765 <b>P.O. Number</b> : <b>This Issue</b> : 05/02/2009 <b>S.O. No.</b> : <b>Prsht Rev.</b> : NC <b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS <b>Previous Run</b> : 45530 <b>Written By</b> : <b>Checked &amp; Approved By</b> : <u>JLD 09-02-06</u> <b>Comment</b> : Est Rev:A 09-02-03 new issue DD verified by:JLM	<b>Drawing Name</b> : AFT LH DOOR HINGE KIT  <b>Part Number</b> : D130780011 <b>Drawing Number</b> : IIN-D130-780 <b>Project Number</b> : N/A <b>Drawing Revision</b> : A <b>Material</b> : <b>Due Date</b> : 28/02/2009 <b>Qty:</b> 1 <b>Um:</b> Each
---	---

**Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 ✓ DC

DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

✓ Photocopy bluefile and type labels per PPP D130-780-011 CHG 001

2.0 ✓ D3813041

Hinge Assembly, Upper Door



**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 1.0000 Each(s)  
Hinge Assembly, Upper Door  
batch: \_\_\_\_\_

3.0 ✓ D3813043

Hinge Assembly, Lower Door



**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 1.0000 Each(s)  
Hinge Assembly, Lower Door  
batch: \_\_\_\_\_

4.0 ✓ D38141

Hinge, Upper Airframe



**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 1.0000 Each(s)  
Hinge, Upper Airframe  
batch: \_\_\_\_\_

5.0 ✓ D38143

Hinge, Lower Airframe



**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 1.0000 Each(s)  
Hinge, Lower Airframe  
batch: \_\_\_\_\_

✓ 561 x D38921 B \_\_\_\_\_

per ECN 09-541 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 05/02/2009 3:30:52 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT LH DOOR HINGE KIT

Job Number: 45531

Part Number: D130780011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



D38161

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

batch: \_\_\_\_\_

7.0



D38163

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

batch: \_\_\_\_\_

8.0



D3817041

Anchor Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Anchor Nut Plate

batch: \_\_\_\_\_

9.0



AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: \_\_\_\_\_

10.0



AN37A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

batch: \_\_\_\_\_

11.0



AN3104

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

NUT

batch: \_\_\_\_\_

12.0



AN417

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: \_\_\_\_\_



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 05/02/2009 3:30:52 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT LH DOOR HINGE KIT

Job Number: 45531

Part Number: D130780011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0



AN9704

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: \_\_\_\_\_

14.0



MS21042L3

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

batch: \_\_\_\_\_

15.0



MS24665212

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cotter Pin

batch: \_\_\_\_\_

16.0



MS24694S46

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Screw

batch: \_\_\_\_\_

17.0



NAS1149D0363J

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: \_\_\_\_\_

18.0



NAS1149D0463J

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: \_\_\_\_\_

19.0



D35527

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Prop

batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 05/02/2009 3:30:52 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT LH DOOR HINGE KIT

Job Number: 45531

Part Number: D130780011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0 ✓ D36221

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Ball Stud

batch: \_\_\_\_\_

21.0 ✓ D38201

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

batch: \_\_\_\_\_

22.0 ✓ MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: \_\_\_\_\_

23.0 ✓ NAS1149D0563J

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: \_\_\_\_\_

24.0 ✓ QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

25.0 ✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-780-011

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

26.0 ✓ QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion ✓



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	Part Number	Description
X						D130-780-041	SPACEPOD™ LH, EC 130 B4
	X					D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X				D130-780-043	DOOR ASSEMBLY, LH
	1		X			D130-780-044	DOOR ASSEMBLY, RH
1				X		D130-780-011	AFT LH DOOR HINGE KIT
1	1				X	D130-780-013	SWITCH RELOCATION KIT
2	2					D3815-041	WEB ASSEMBLY
						D2464-0360	NEOPRENE SEAL
		1	1			D2589	KEYS, KEY CHAIN
1	1					D3837-1	DECAL
1	1					D3015-3	LOCK NUT
		1				D3186-3	SPACEPOD™ DOOR, LH
			1			D3186-4	SPACEPOD™ DOOR, RH
1						D3798-041	FLOOR
	1					D3798-042	FLOOR
1						D3188-5	SPACEPOD™ BODY
	1					D3188-6	SPACEPOD™ BODY
1	1					D3547-1	BRACKET
1	1					D3550-1	STRUT
		1	1			D3552-7	GAS SPRING
1	1					D3554-7	BALL STUD
4	4					AN3-3A	BOLT
4	4					AN3-6A	BOLT
2	2					AN3-10A	BOLT
1	1					AN5-5A	BOLT
38	38					AN525-10R7	SCREW
8	8					AN526C832R14	SCREW
7	7					MS24694S67	SCREW
1	1					MS24694S69	SCREW
		2	2			MS27039-0811	SCREW
8	8					A3235-020-935	WASHER
8	8					NAS1149D0363J	WASHER
16	16					NAS1149D0332J	WASHER
		4	4			NAS1149DN832J	WASHER
3	3					NAS1149D0563J	WASHER
		2	2			NAS1515H3	NYLON WASHER
		2	2			MS21042L08	NUT
16	16					MS21042L3	NUT (or MS21042-3)
1	1					MS21042L5	NUT
10	10					AKS7-1032-130	INSERT
28**	28**					AKS7-1032-130	INSERT
					2	D3819-1	MALE SPADE CONNECTOR
					2	D3597-1	FEMALE SPADE CONNECTOR

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Revision: A

Date: 08.10.07

NO.

45531

-041	-042	-043	-044	-011	-013	Part Number	Description
					1	D3598-2-096	EXPANDABLE SLEEVE
					24	D3599-1	TIE-WRAP
					24	D3600-1	TIE-WRAP MOUNT
					24 FT	M22759/41-22-9	WIRE
		1*	1*			D2464-1250	NEOPRENE SEAL
1**		1*				D3837-3	DECAL
	1**		1*			D3837-4	DECAL
		2*	2*			D2586	LATCH
		2*	2*			D2585	MOUNTING CHANNEL
		2*	2*			D2621	LATCH PLATE
		2*	2*			MS27039-1-15	SCREW
		2*	2*			NAS1149D0363J	WASHER
		2*	2*			MS21042L3	NUT (or MS21042-3)
		1*	1*			D2857-1	HINGE BRACKET
		1*	1*			D2857-2	HINGE BRACKET
		2*	2*			D2228	BACKING PLATE
		8*	8*			AN526C832R10	SCREW
		8*	8*			NAS1149DN832J	WASHER
		8*	8*			MS21042L08	NUT
		1*	1*			D3557-1	BRACKET
		2*	2*			D2228	BACKING PLATE
		1*	1*			D3554-7	BALL STUD
		1*	1*			NAS1149D0563J	WASHER
		1*	1*			D3015-3	LOCK NUT
		2*	2*			AN526C832R14	SCREW
		2*	2*			AN526C832R10	SCREW
		4*	4*			NAS1149DN832J	WASHER
		4*	4*			MS21042L08	NUT
2**	2**					D2237	STRIKER PLATE
4**	4**					MS20426AD4-5	RIVET
2**	2**					D3538-1	HINGE BRACKET
2**	2**					D2179	HINGE BRACKET PLATE
4**	4**					AN526C832R24	SCREW
4**	4**					NAS1149DN832J	WASHER
4**	4**					MS21042L08	NUT
				1		D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1		D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***		D3518-3	ROD END
				2***		NAS509-6	NUT
				1		D3814-1	HINGE, UPPER AIRFRAME
				1		D3814-3	HINGE, LOWER AIRFRAME

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Revision: A

Date: 08.10.07

SUP COPY  
 24531R

-041	-042	-043	-044	-011	-013	Part Number	Description
				2		D3816-1	SPACER
				4		D3816-3	SPACER
				1		D3817-041	ANCHOR PLATE
				2		AN3-5A	BOLT
				3		AN3-7A	BOLT
				2		AN310-4	CASTLE NUT
				2		AN4-17	BOLT
				2		AN970-4	WASHER
				5		MS21042L3	NUT
				2		MS24665-212	COTTER PIN
				3		MS24694S46	SCREW
				8		NAS1149D0363J	WASHER
				2		NAS1149D0463J	WASHER
				1		D3552-7	GAS SPRING
				2		D3622-1	BALL STUD
				1		D3820-1	DOOR SUPPORT
				2		MS21042L5	NUT
				2		NAS1149D0563J	WASHER

\* Pre-installed on D3186-3/-4 Spacepod™ Door

\*\* Pre-installed on D3188-5/-6 Spacepod™

\*\*\* Pre-installed on D3813-041/-043 Hinge Assemblies

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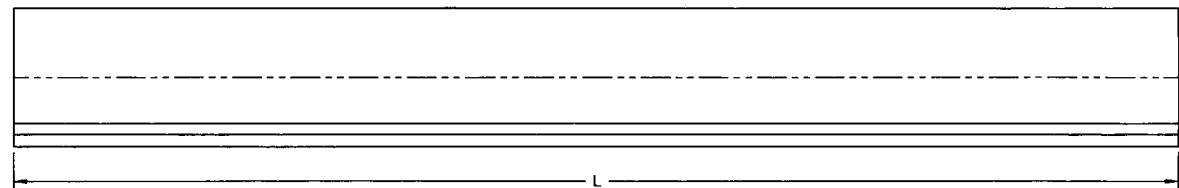
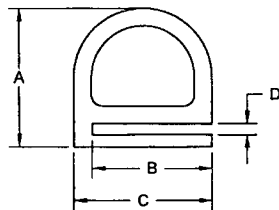
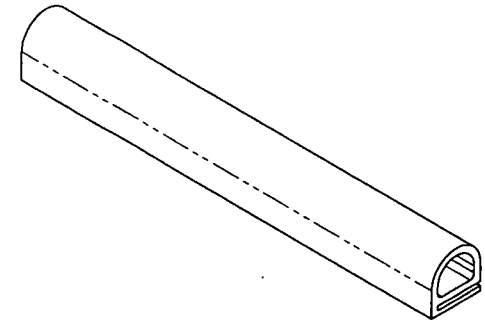
REVISION

DATE

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# SPECIFICATION CONTROL DRAWING



**D3892-X SEAL**

DART P/N	A	B	C	D	L	DUROMETER	MATERIAL	SUPPLIER	SUPPLIER P/N
D3892-1	0.594 (19/32)	0.516 (33/64)	0.594 (19/32)	0.047 (3/64)	5.00	60	BLACK BUNA-N	SPAENAUER	825-221

**RELEASED**  
01/23/10

**REFERENCE ONLY**

## NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.01.26
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.26		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3892** REV. A  
SHEET 1 OF 1

TITLE **SEAL** SCALE  
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